

Date: Tuesday, 4/17/2007 3:47:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 31889	
Estimate Number : 10314	
P.O. Number : <i>N/A</i>	Part Number : D265613
This Issue : 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 30553	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/10/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 40 Um: Each
Comment : Est: 02.10.25 Re-format KJ/RF Est Rev:G Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.8500 sf(s)/Unit Total : 34.0000 sf(s)
 1010/1025/A21/6aA SHEET

BAH M1010453

SAD 07/05/27

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: *D*
 Prog Rev: *D*

2-Deburr if necessary

SAD 07/06/12

SAD 07/05/27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/27

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SB 07.05.28

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158Identify as D2656-13

SB 07/06/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 21/06/26

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:47:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31889

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Conto
F/En 07/06/21 (40X)

7.0

POWDER COATING

POWDER COATING



M101 601



(40X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/06/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX

07/06/25

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-15

m-l

07/06/25

(40X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/26

Job Completion



U 07/06/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

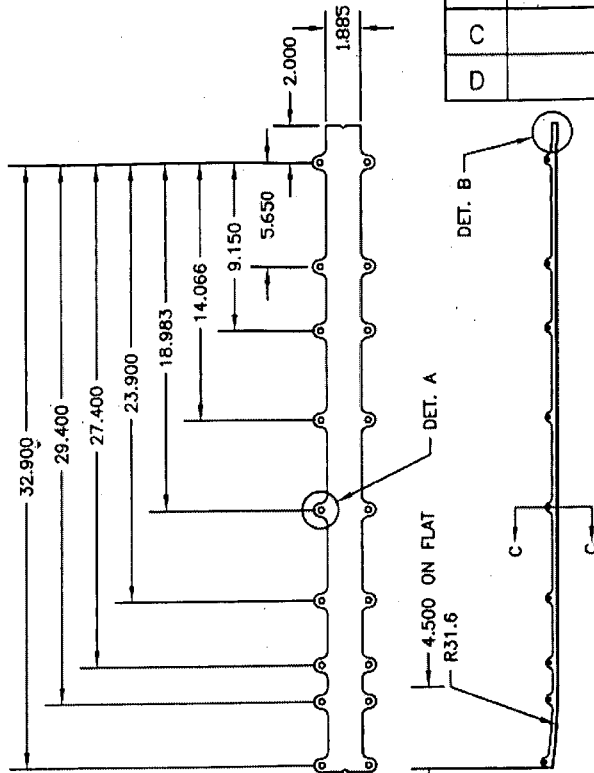
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

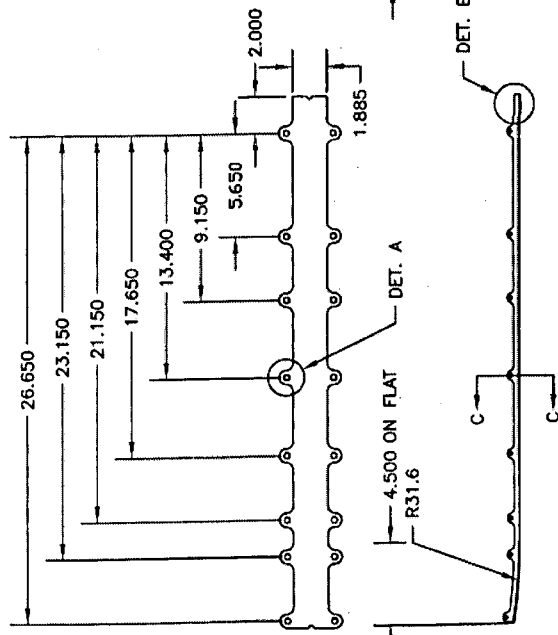


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CHECKED 		APPROVED 		DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17			TITLE WEARSHOE		SCALE 1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

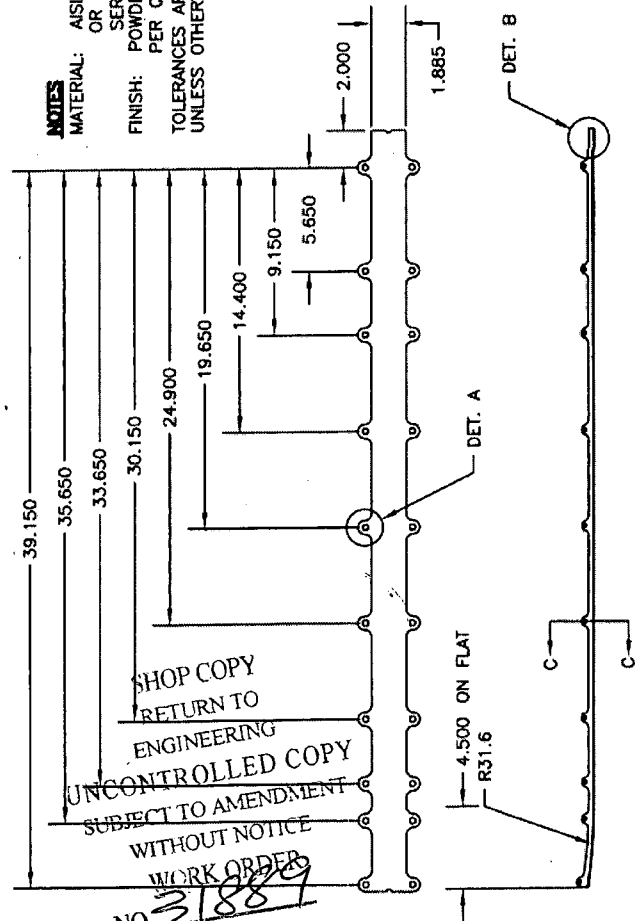
D2656-13



D2656-11



D2656-15



NOTES:
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
 OR CSA C40-21, 38W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
 PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

RELEASED
 05-09-08

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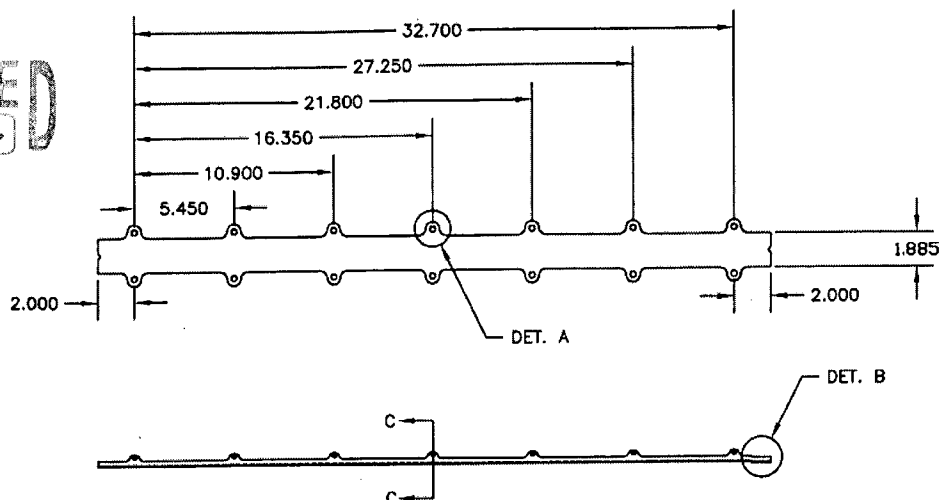
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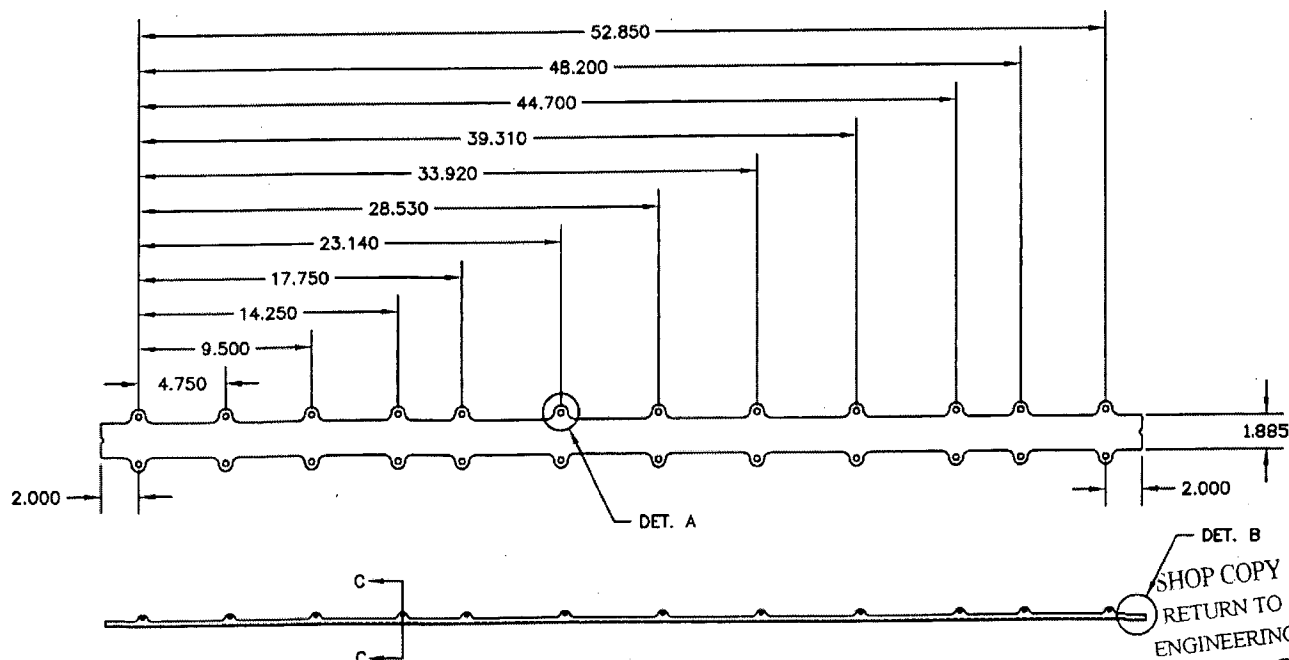
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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05.07.06 *[Signature]*

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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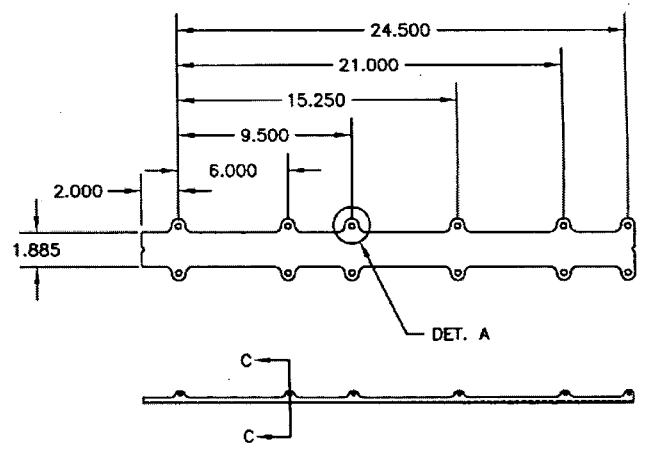
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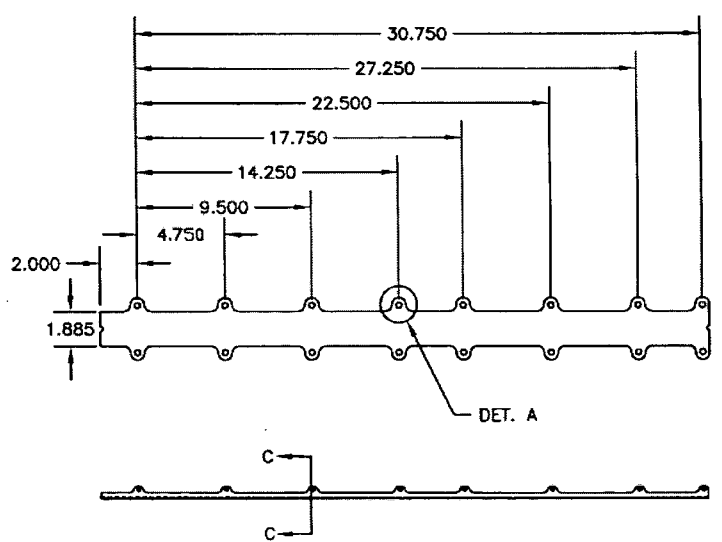


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		TITLE	WEARSHOE	SHEET 3 OF 4
				SCALE 1:10

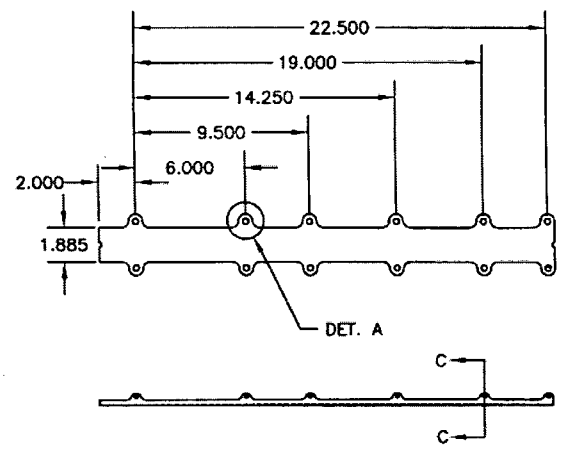
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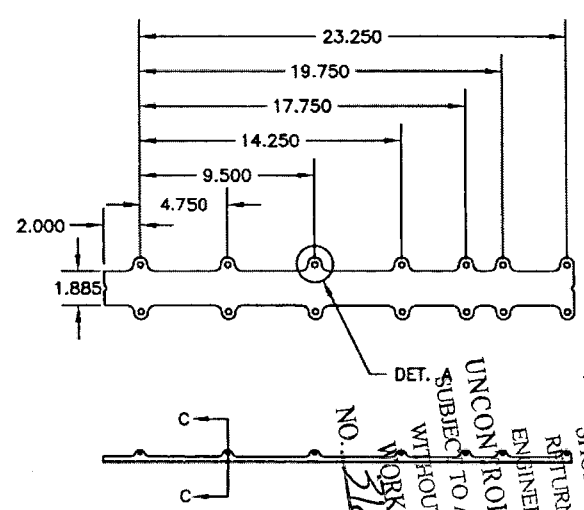
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D2656-31



D2656-35



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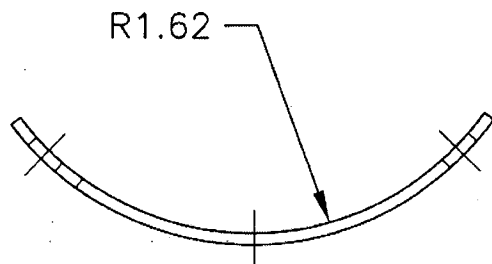
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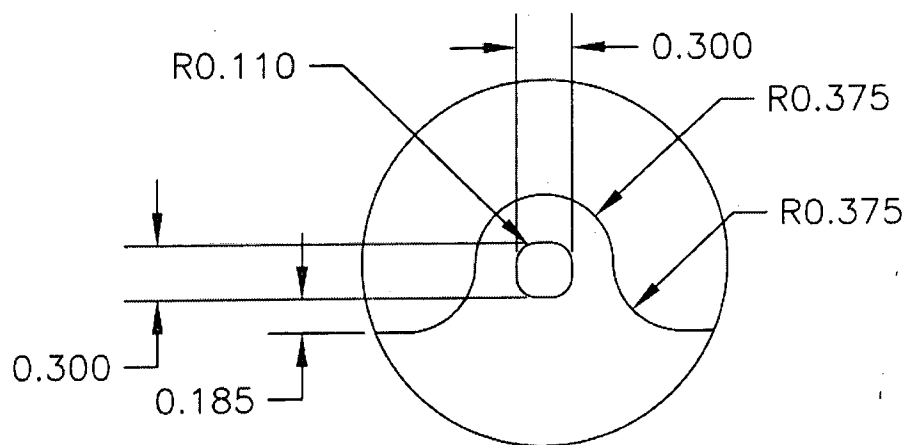
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

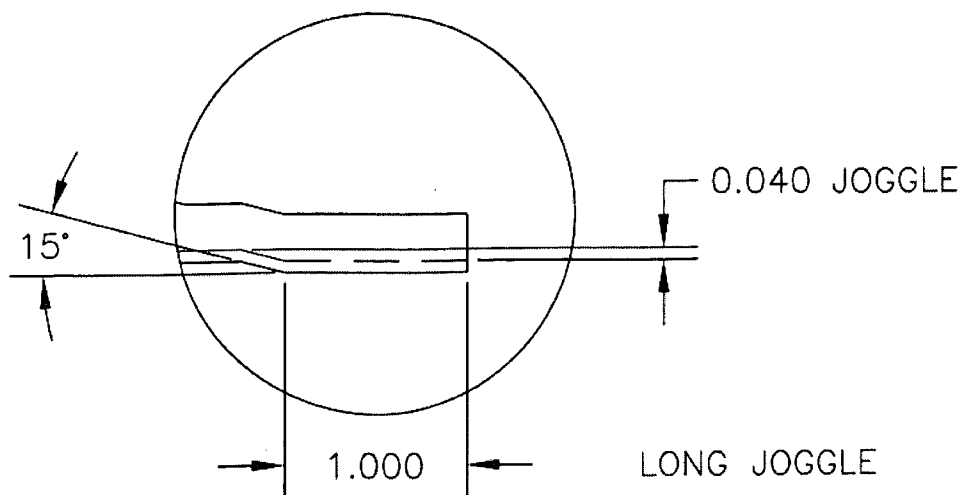


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DETAIL A



DETAIL B



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